

Date: Friday, 7/4/2008 8:47:06 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FITTING		
Job Number	40257					
Estimate Number	11396					
P.O. Number			Part Number	D32993		
This Issue	7/4/2008	S.O. No.	Drawing Number	D3299 REV B		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	B		
Previous Run	35139		Material			
Written By			Due Date	7/30/2008	Qty:	6 Um: Each
Checked & Approved By						
Comment	Est: A 04.10.04 New issue KJ/JLM					

## Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1000	6061-T6 1" HexBar
		
Comment: Qty: 0.1925 f(s)/Unit Total: 1.1548 f(s) 6061-T6 1" HexBar Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex (M6061T6H1.000) Identify as D3299-3 Batch: M105233		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: Machine as per Folio FA452 and Dwg D3299 Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK		
5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
		
Comment: Sub-Contracting OUTSIDE SERVICES Issue P/O: 6865 Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		'00 00					

Part No: D3299-3\* PAR #: N/A Fault Category: Machining NCR: Yes No DQA: H Date: 08.08.21  
 D412-706-011 QA: N/C Closed: H Date: 08.08.21

NCR: 40257		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.16	2.0	3 parts scrap. Chunks missing cut off the thread!  R.C.: Crooked insert; tool catching the edge of the thread.	QSL042	- Scrap - no replace. - Set-up already removed.		108.07.16	QSL042	08.07.16
08.07.16	2.0	3 parts 0.030" over tolerance on the center, resulting in being 0.030" too long on the total length.  R.C.: Program: parts were not inspected on the F.A.I., until the cycle was complete.	QSL042	- Revise Program to correct the length. - Ensure F.A.I. is always done with the 1st part. - parts acceptable per F.M.I. - oddball All parts scrap. Qty 30 Replace B# M105338	JUL 10.2 8/7/16	S 8/7/16	QSL042	08.07.16
↓	2.0		QSL042			8/7/16	QSL042	08.07.16

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 8:47:06 AM  
User: Kim.Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 40257

Part Number: D32993

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

CL081021/18 (3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 32

8/8/18

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2018

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40257
Description: Fitting	Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B 9/2019	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

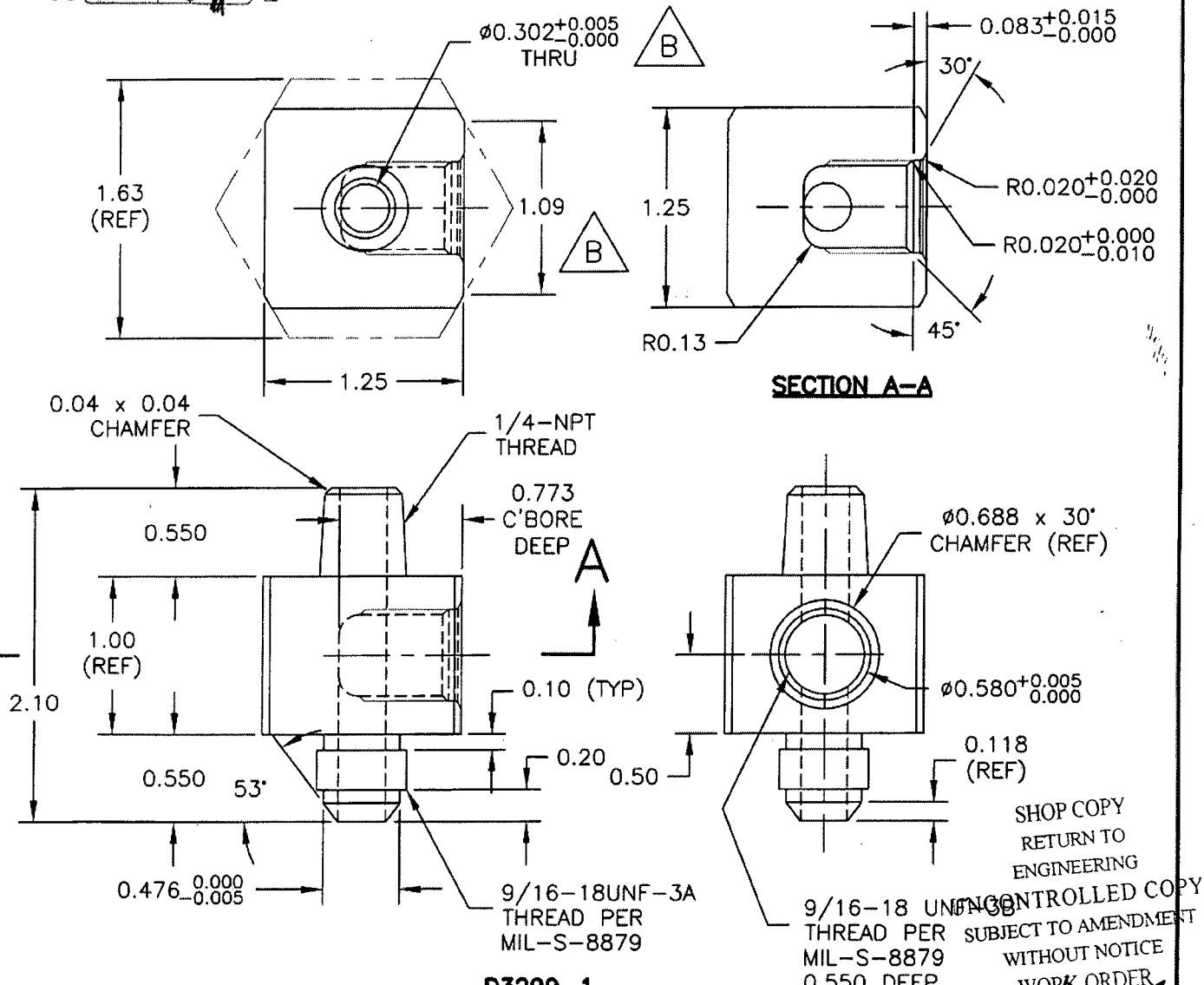
## X First Article Prototype

Measured by:	<u>MME</u>	Audited by:	<u>JNL</u>	Prototype Approval:	N/A
Date:	08/07/11	Date:	08/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	<i>[Signature]</i> <i>[Signature]</i>

**DART**

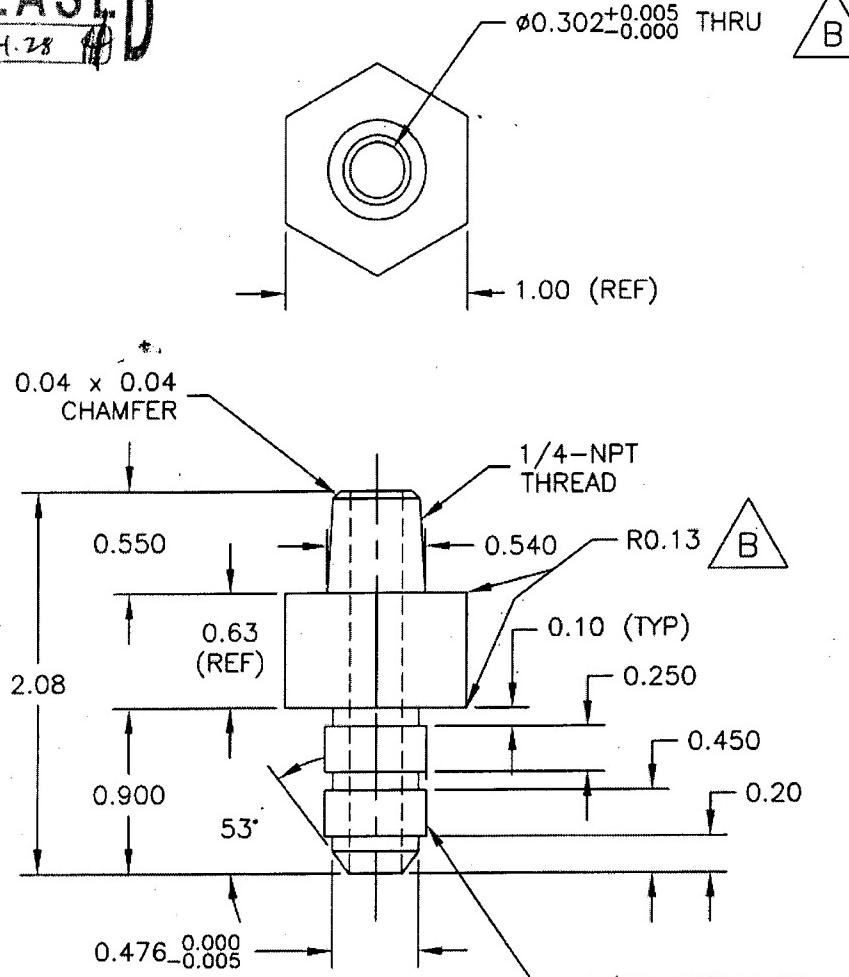
DESIGN <i>P</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; Ø0.302 WAS Ø0.297	

**RELEASED**  
*05.04.28 H***D3299-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

**RELEASED**  
05.04.28

SHOP COPY  
RETURN TO  
ENGINEERING  
9/16-18UNF-3A  
THREAD PER MIL-S-8879  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40251

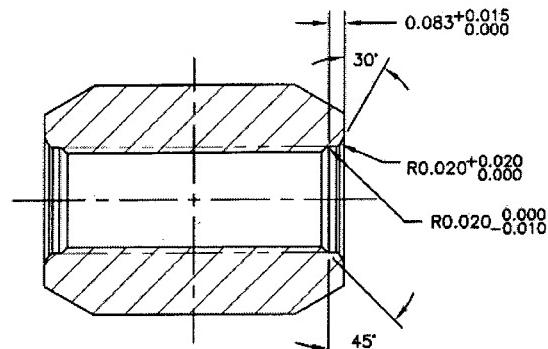
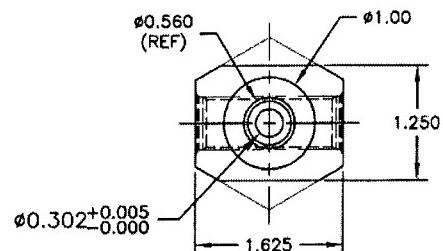
**D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

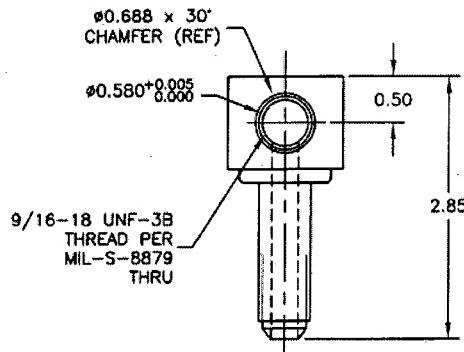
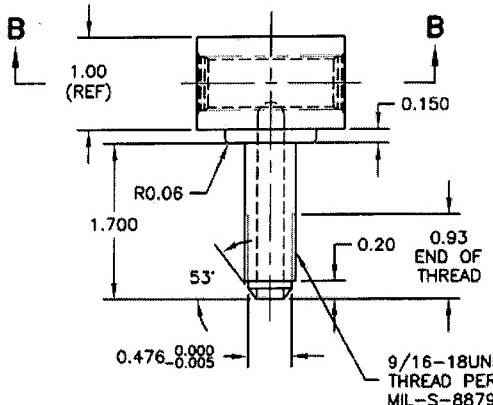
**DART**

DESIGN <i>#</i>	DRAWN BY <i>#</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED  
05.04.28 *#*



**SECTION B-B**  
SCALE 1:1



**D3299-5**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *40257*

**D3299-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

## **Jason Murdoch**

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**From:** Roberto Fuentes [rfuentes@dartaero.com]  
**Sent:** July 16, 2008 9:14 AM  
**To:** 'Jason Murdoch'  
**Subject:** RE: Emailing: CCF15072008\_00000

Hi Jason,

Those dimensions doesn't affect function and operation of D3299-3 Fitting in Canister, therefore is acceptable.

Roberto

-----Original Message-----

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]  
Sent: Wednesday, July 16, 2008 5:34 AM  
To: 'Roberto Fuentes'  
Subject: Emailing: CCF15072008\_00000

The message is ready to be sent with the following file or link attachments:

CCF15072008\_00000

Note: To protect against computer viruses, e-mail programs may prevent sending or receiving certain types of file attachments. Check your e-mail security settings to determine how attachments are handled.

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

67086

07-Aug-2008

## CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1170 ABERDEEN STREET  
WINKESBURY, ONTARIO  
N8A 1K7CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITENO. DE COMMANDE:  
PURCHASE ORDER/

PO00006865



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	6	6	D3299-1 B40301	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	8	8	D3299-3 B40257	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
3	4	4	D3299-5 B40302	REV. B BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

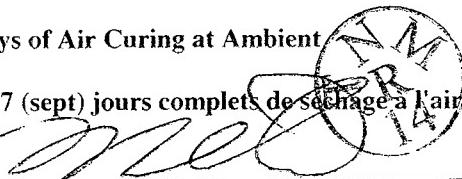
Je certifie que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

The parts are processed, tested, and inspected to the requirements of above specifications.  
Work cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:



Directeur de la Qualité / Q.A. Manager